

Work Order ID 66135

Monday, February 07, 2011 10:59:00 AM

Page 1

Item ID: D3537-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearpad

Start Date: 2/8/2011 Start Qty: 40.00

Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan:

Date: 11-02-07 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

3.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev. C Prog Rev. C 2-Deburr
if necessary

11-2-9

48

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-2-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ml

11

02

08

48

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Page 2

Item ID: D3537-1

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Revision ID:

Item Name: Wearpad

Start Date: 2/8/2011 Start Qty: 40.00

Required Date: 2/22/2011 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

0.00

0.00

0.00

0.00

0.00

0.00

140



Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 205913 Hardcoat
M117332 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

8 11/05/12

SP 11/02/10

EL 11-5-2

+26

+28

48

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Page 3

Item ID: D3537-1

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Start Date: 2/8/2011 Start Qty: 40.00

Required Date: 2/22/2011 Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref 4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



Sublot

*count
+28*

M 115128

3:20 1:55

2:25

28 AR 11-5-2

28 of 211 sublot

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Start Date: 2/8/2011 Start Qty: 40.00

Required Date: 2/22/2011 Req'd Qty: 40.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location

EP-12

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

28 0 11/15/10

11/15/34

11/15/10

Picklist Print

Monday, February 07, 2011 10:58:57 AM

Page 1

Work Order ID: 66135

Parent Item: 13537-1

Parent Item Name: Wearpad



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: JPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	222.2800	0.106	4.463158		5.1	
										11-2-9			

304/316 Sheet .063

Location

Loc Qty

Loc Code

MA1

222.28

11323

0

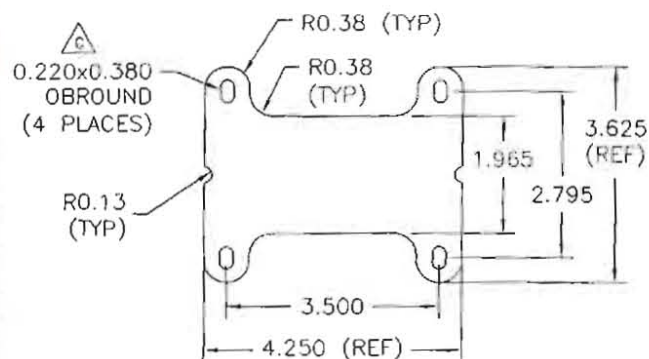
116623

222.28

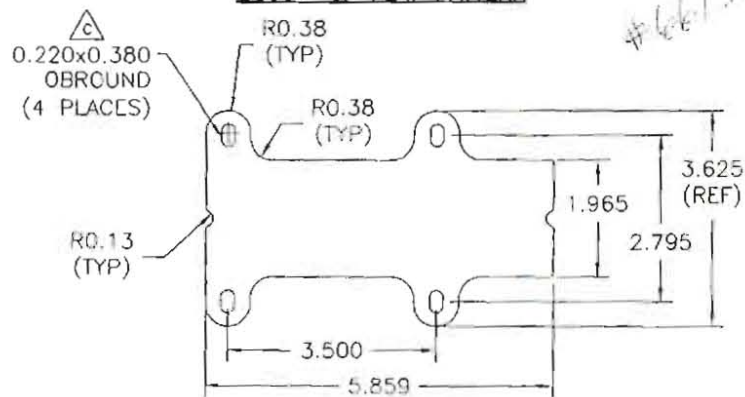
116623

48

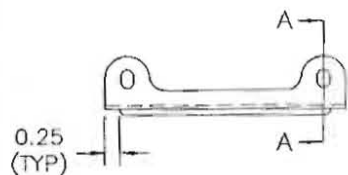
D3537-1F FLAT PATTERN



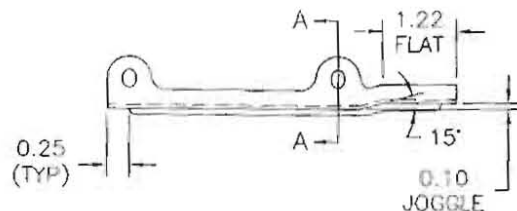
D3537-3F FLAT PATTERN



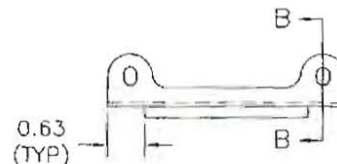
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



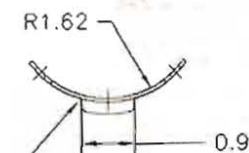
D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

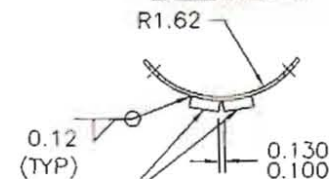
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



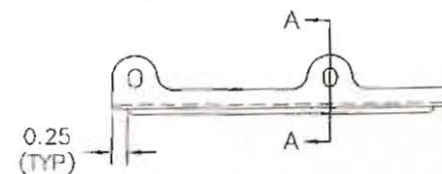
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



RELEASED
07-05-03
DART
962

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	07.04.13	DRAWING NO. D3537
		TITLE WEARPAD
		REV. C
		SHEET 1 OF 1
		SCALE 1:2

DART AEROSPACE USA, INC.
FORT WORTH, TX